

Date: Wednesday, 10/10/2007 11:03:47 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 35084
Estimate Number : 11228
P.O. Number :
This Issue : 10/10/2007 S.O. No. :
Prsht Rev. : NC
First Issue : 1/1 Type : R&D THERMOFORMING
Previous Run : 33899

Drawing Name : FLOOR PROTCOR AFT LH

Part Number : D32813
Drawing Number : D3281 REV B
Project Number : N/A
Drawing Revision : 8
Material :
Due Date : 11/2/2007 Qty: 20 Um: Each

Written By :
Checked & Approved By :
Comment : Est Rev:A 04.07.01 New issue KJ/JLM
Est Rev B 07.08.07 Thermoform in house DL

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

F6002 701

lexan black



Comment: Qty.: 4.3600 sf(s)/Unit Total: 87.2000 sf(s)
lexan black .125"

Material Batch #

M106957

2.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks

B 08/01/30

3.0

THERMOFORMING

THERMOFORMING MACHINE



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D32811and Folio FTA 009

Dwg. Rev. B

Folio Rev.

B 08/01/30 X10.

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B. 08/01/30 X10

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTECTOR AFT LH

Job Number: 35084

Part Number: D32813

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



X10

Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

08.01.07
08.02.04 X10

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



X10

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

08.01.07

2) Check dimensions to ensure conformity to drawing tolerances.

08.02.05 X10

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08.01.07
08.02.05 X10

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

08.01.07

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.01.07
08.02.06 X10

Job Completion



08.01.07
08.02.06

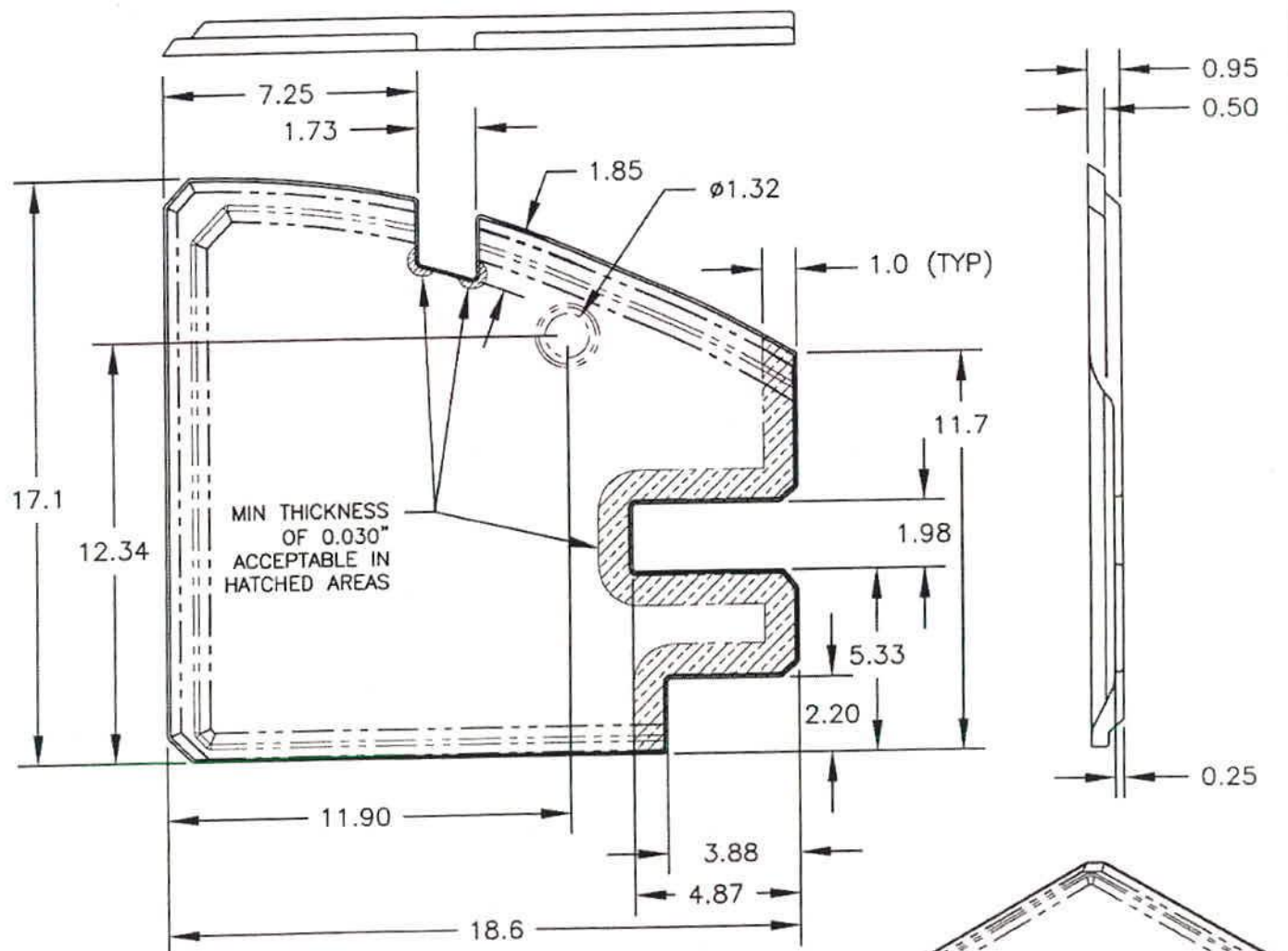
POSITIVE RECALL

EFFECTIVE 08.10.12 AUTH h

RELEASED h DATE 08.01.04



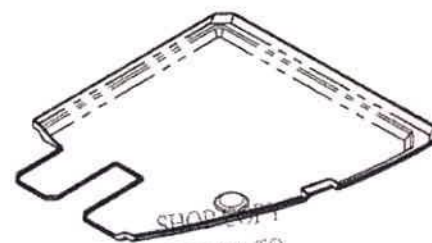
DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3281	REV. B SHEET 1 OF 3
DATE 05.11.25	TITLE FLOOR PROTECTOR		SCALE 1:5
A	04.05.03	NEW ISSUE	
B	05.11.25	NOW LEXAN; DIMS AS MANUFACTURED	



RELEASED
05.12.01

UNDER REVIEW

07.10.05 LE
OK TO MANUFACTURE
AND SHIP



SHOPEX
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. _____

D3281-1 FLOOR PROTECTOR, FWD LH

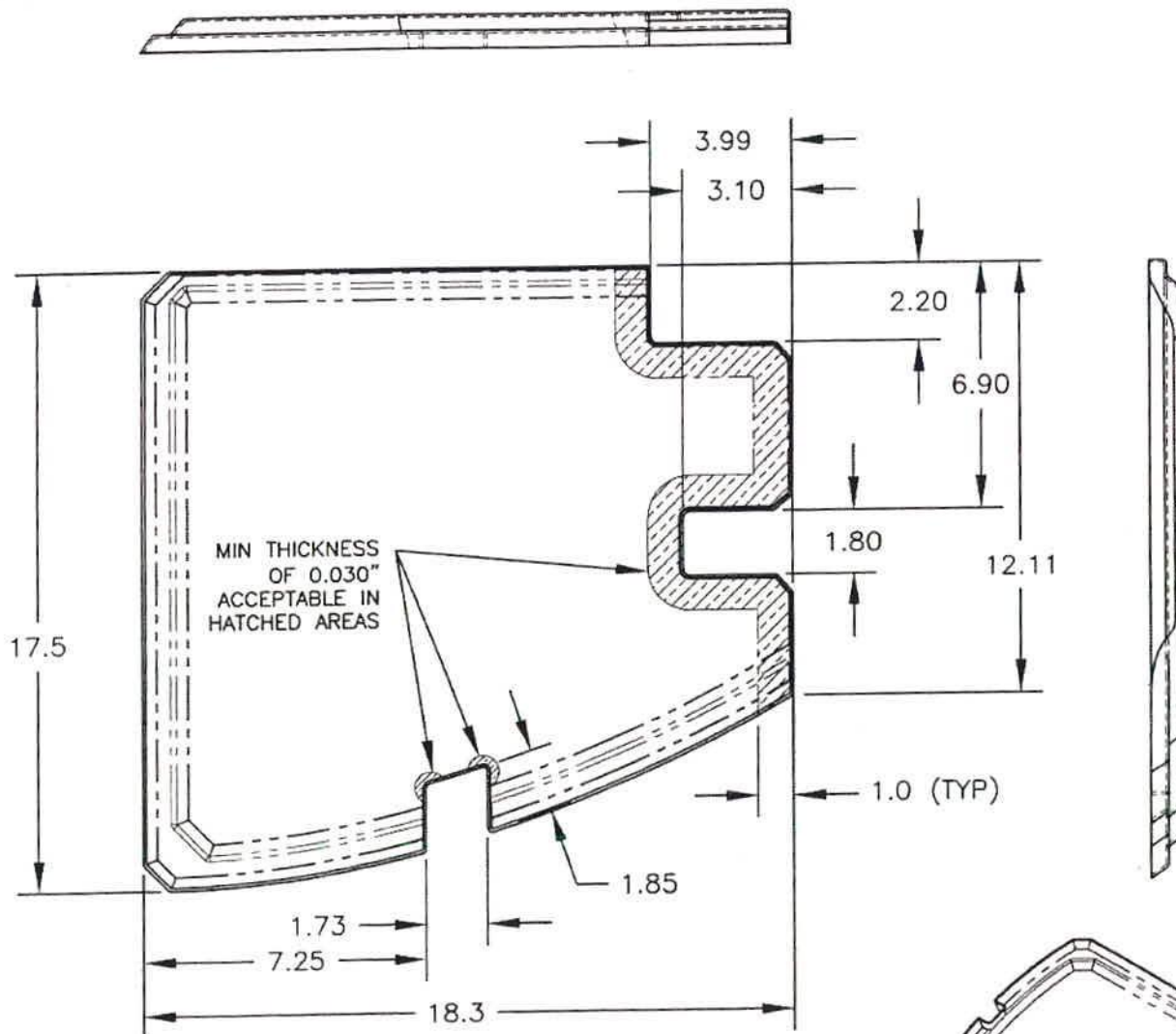
- 1) THERMOFORM D3281-1 USING MOLD D3281-1T1, TRIM USING D3281-1T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HA</i>	APPROVED <i>HA</i>	DRAWING NO. D3281	REV. B SHEET 2 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5

**RELEASED**
05.12.01 *HA***UNDER REVIEW**07.10.05 *LE*
OK TO MANUFACTURE
AND SHIPSHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. _____**D3281-2 FLOOR PROTECTOR. FWD RH**

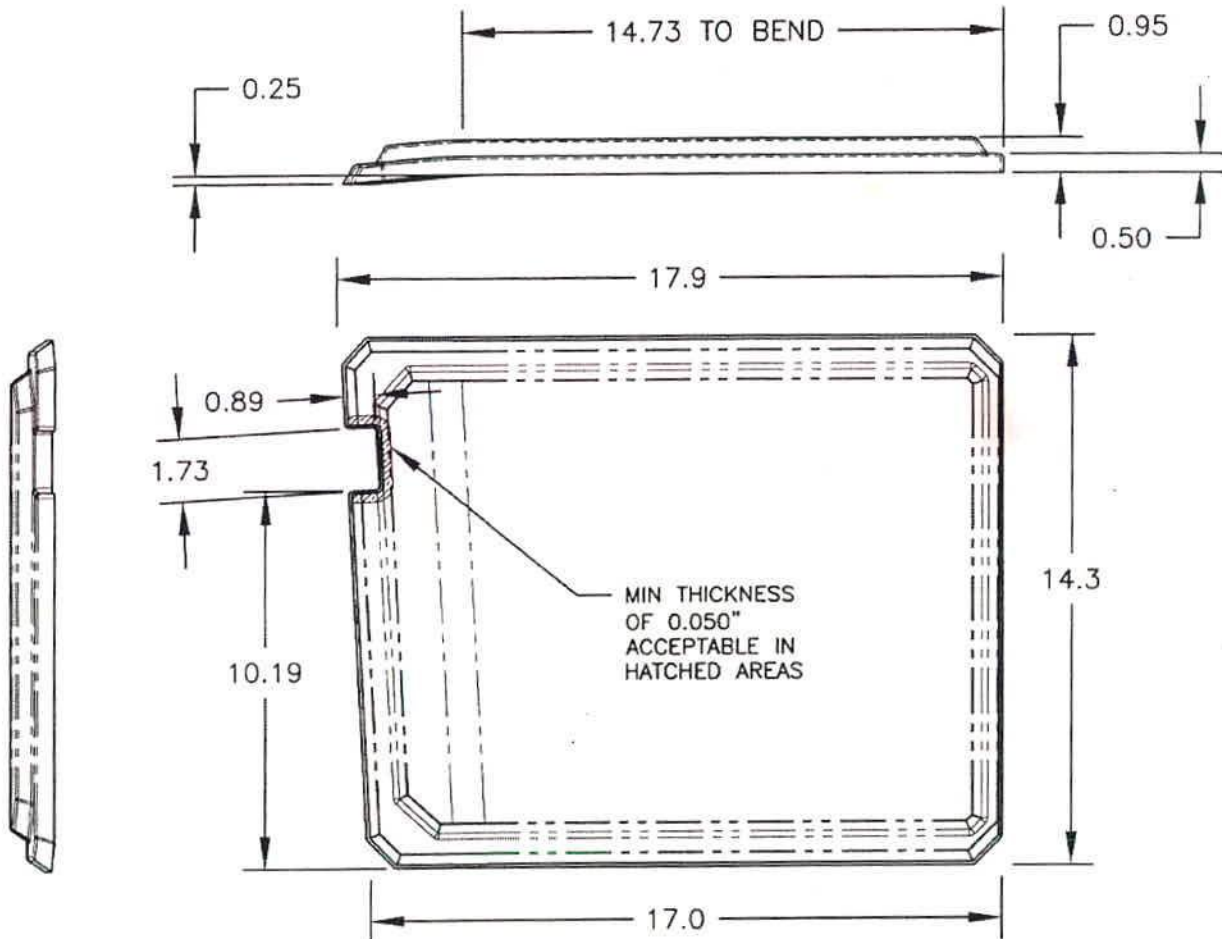
- 1) THERMOFORM D3281-2 USING MOLD D3281-2T1, TRIM USING D3281-2T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

Copyright © 2004 by DART AEROSPACE LTD

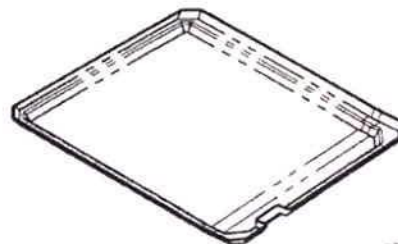
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3281	REV. 8 SHEET 3 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5

**RELEASED**
05.2.01. *[Signature]***UNDER REVIEW**

07.10.05 LE

OK TO MANUFACTURE
AND SHIP

D3281-3 FLOOR PROTECTOR, AFT LH (SHOWN)
D3281-4 FLOOR PROTECTOR, AFT RH (OPPOSITE)

- 1) THERMOFORM D3281-3 USING MOLD D3281-3T1, TRIM USING D3281-3T2
THERMOFORM D3281-4 USING MOLD D3281-4T1, TRIM USING D3281-4T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. _____

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART AEROSPACE LTD		Work Order: 35084-2
Description: R-44 Floor Protector AFT LH		Part Number: D3281-3
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 3/16" 40/NO 40	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: 	Date: 08/01/30
--	----------------

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
17.9	.1	17.8	✓			
14.3	.1	14.25	✓			
10.14	.1	10.125	✓			
.95	.030	.963	✓			
.25	.030	.240	✓			

Measured by: 	Date: 08.02.07
Audited by: 	Date: 08/02/04
Prototype Approval: 	Date: 

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

